



Dart Aerospace Ltd.
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Canada

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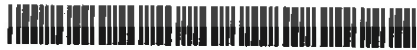
D5336-041
Job Sheet 200492



Part No: D5336-041

Job Qty: 1 pcs

Part Name: Basket Lid Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/12/19

Job Tracking No:

Due Date: 10/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEETS 1,2,3,7 IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM IPP REV:B 17.03.27 AS PER REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	10/4/19	10/4/19	0.00	8.02	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		DAS 43
							Large Fab - 6		9-89
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	10/4/19	10/4/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		DAS 24
							QC 9 - 43		
							QC 9 - 50		9-89
							QC 9 - 9		
120	QC 5	1	10/4/19	10/4/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		DAS 24
							QC 5 - 24		
							QC 5 - 3		9-89
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 56		
							QC 5 - 68		



Container No: S220047



Part: D5336-041

Job No: 200492

Serial No/Batch: S220047

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Date: 10/05/19

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					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
130 Powdercoat - 4 Black Sand - B4B	1 pcs	10/4/19	0.00 0.11	Powdercoat - 1 - B4B		
<i>MISG440</i> <i>START: 8:55 OUT: 3:10 FINISH: 9:25</i>				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		<i>BL 19-10-8</i>
				Powdercoat - 4 - B4B		
140 Handfinish - 3-1- WingWalk - B4B	1 pcs	10/4/19	0.00 0.75	Handfinish - 3 - 1 - B4B		<i>HL 19-10-02</i>
				Handfinish - 3 - 2 - B4B		
				Handfinish - 3 - 3 - B4B		
				Handfinish - 3 - 4 - B4B		
				Handfinish - 3 - 5 - B4B		
150 QC 3	1 pcs	10/4/19	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		<i>BER 19-10-08</i>
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
				QC 3 - 43		
				QC 3 - 24		
				QC 3 - 61		
				QC 3 - 81		
160 Packaging 3-1 - Stock - B4B	1 pcs	10/4/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		<i>HL 19-10-8</i>
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		

				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	1	10/4/19	0.00 0.00	QC 21 - SA - 21	DAS
	pcs			QC 21 - SA - 70	21 OCT 09 2019
				QC 21 - SA - 53	9-89

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: 4130138) 1- Assemble ribs , weld as per dwg D5336 using DT10196 2- Weld Descriptions: hinge (3) and Mounting brackets as per dwg D5336 ***inspect before welding mesh*** 3- Cut mesh as per dwg D5334-1 4- Tack weld mesh on basket as per dwg D5336 ***Make sure to place mesh correctly on lid, check with label plate before tacking mesh***

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) *** Mask holes and sides of hinge prior to powdercoat*** Start Time: _____ Oven Temperature: _____ Finish Time: _____

140 - (Wing Walk as per dwg QSI005 4.4 Batch _____) 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

150 - (QC3- Inspect Part Finish)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

#011964

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5211240 → 2x
D4016-3 ✓	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1	5193147 → 2x
D5332-041 ✓	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	5192413 → 2x
D5332-1 ✓	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5213638
D5332-13 ✓	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	3117495 → 3x
D5332-15 ✓	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5192525 → 2x
D5332-19 ✓	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5191807 → 2x
D5335-1	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5215767
M304EX0.75-16F	Expanded Metal Flat SS	8.1600 sf (8.16 ea)	100-Large Fab - Basket - 1	5206463

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	87	0
	D4016-3	3	57	0
	D5332-041 ✓	2	0	0
	D5332-1 ✓	2	0	0
	D5332-13 ✓	3	3	0
	D5332-15 ✓	2	5	0
	D5332-19 ✓	2	2	0
	D5335-1	1	0	0
	M304EX0.75-16F	8	883	0

Part Specifications	
Specifications could not be found.	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐				DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐				Date : _____ Sequence #: _____		QTY Affected : _____		MRB (QSI042) _____																															
Description Work Order Deviation						Disposition																																							
Completed By						Lead hand / Supervisor						QC / QA Coordinator																																	
Root Cause Operator ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐						FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>												Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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